

Date: Monday, 8/21/2006 2:13:12 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RING
Job Number : 28267B
Estimate Number : 10395
P.O. Number : N/A Part Number : D29685
This Issue : 8/21/2006 S.O. No. : N/A Drawing Number : D2968
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B1
Previous Run : 27924B Material : N/A
Due Date : 9/20/2006 Qty: 40 Um: Each
Written By :
Checked & Approved By :
Comment : Est:C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M4130NT3000W500 4130 Tube 3"ODx.5"W



Comment: Qty.: 0.0218 f(s)/Unit Total: 0.8736 f(s)

Material: AISI 4130 3/4" Bar

(M4130N-R0.750)

Batch: M102020

Identify AS D2968-1

S.G. 06/09/07

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

PLG



Issue to turn per drawing D2968-1



06-09-07

Comment: MORI SEIKI LATHE

1-Turn Blank as per Folio FA049 and Dwg D2968

2-Deburr, no sharp edges

Review + inspect for transit damage

06/09/20

(40)

3.0 QC8 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

48/5.G

06/09/20

(40)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

N/A

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S+396

06/09/21 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/21

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



40

Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/20

Job Completion



U 06/09/21

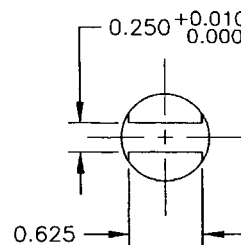
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D2968-1/-3 STEM

AND D2968-3 STEM:

MATERIAL: AISI 4130

$\Delta \phi 0.750$ O.D.

2 $\varnothing 0.625$ O.D.

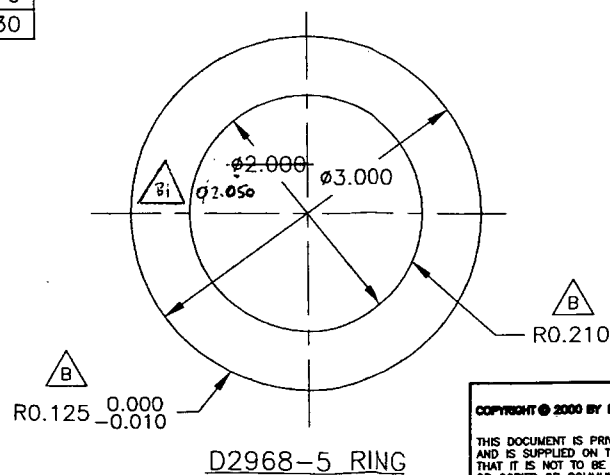
3. MACHINE UNIFORM TAPER FROM $\phi 0.363$ O.D.
TO $\phi 0.625$ O.D.

1/4-28 UNF THREAD WITH 0.063 GRIP
MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
UNLESS OTHERWISE INDICATED
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



RELEASE
00-06-04

~~UNDER REVIEW~~


USE 2968-1 STEM
FOR -041
USE 2968-3 STEM
FOR -043

D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI
FINISH: CAD PLATE ENTIRE ASSEMBLY PER

POWDER COAT WHITE (REF 4.3.5.2) PER DART
QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN #	DRAWN BY RF	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED #	APPROVED #	
DATE 00.05.31	TITLE TOW RING	REV. B SHEET 1 OF 1 SCALE 1:1

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

WORK ORDER
NO. 28267B

**CERTIFICATE OF CONFORMITY**

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28318	1987
20	DSK101	Support as per Dwg DSK101 D6103-003 B 28319	1987
40	D2968-5	Ring M4130NT3000W500 M102020 W/O 28267B	1987
20 22	D2968-5	Ring M4130NT3000W500 M102020 W/O 28268B	1987
20 22	D3407-5	Ring M174R3000 M18742 W/O 28333	1987

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shirley (Regula) Walz

Vankleek Hill, September 20, 2006